

| | | |
|--------------------|--------------|-------------|
| DART AEROSPACE LTD | Work Order: | 22628 |
| Description: Frame | Part Number: | D3240-1 |
| Dwg: D3240 Rev. B | Qty: | 40 |
| Ref: | | Page 1 of 1 |

| Step | Location | Procedure | By | Date | Qty |
|------|----------|---|-----|----------|-----|
| 1 | DC | Issue Traveler | KJ | 05.03.09 | 40 |
| 2 | PG | Issue P/O: <u>2004686</u> Email or Ship DXF file to vendor Laser Cut flat pattern per Dwg D3240 Possible Supplier: GFI Material release note is required | | 05.03.09 | 40 |
| 3 | RG | Receive and Inspect for transit damage Ensure material release note is attached | CL | 05/04/06 | 40 |
| 4 | QC6 | Inspect dimensions as per Dwg D3240 | KL | 05.04.07 | 40 |
| 5 | GA | Deburr if necessary | 2 | 05.04.08 | 40 |
| 6 | ST | Identify and Stock | CL | 05/04/19 | 40 |
| 7 | AC | Cost / part <u>42.43</u> | SGC | 05.04.21 | 40 |
| 8 | DC | Close W/O <u>42.41</u> Inspect Level 21 | KJ | 05.04.22 | 40 |

| Rev | Date | Change | Revised By | Approved |
|-----|----------|-----------|------------|----------|
| A | 04.03.08 | New issue | KJ/JLM | |

4/10/08

SB FP *Acid Etch & Alodine per WSF005 4.1*

M/B 05/04/14 40 *4/10*

RELEASED

05.03.09

| W/O: | | WORK ORDER CHANGES | | | | | |
|----------|------|---------------------------------|----|----------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Mfg / Design Mgr | Approval QC Inspector |
| 05.04.14 | 5b | Permanent change, add Step 45B. | JH | 05.04.07 | N/A | W | BB 04.29 |
| | | | | | | | |

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Design Mgr | Approval QC Inspector |
| | | | Initial Design Mgr | Action Description Design Mgr | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

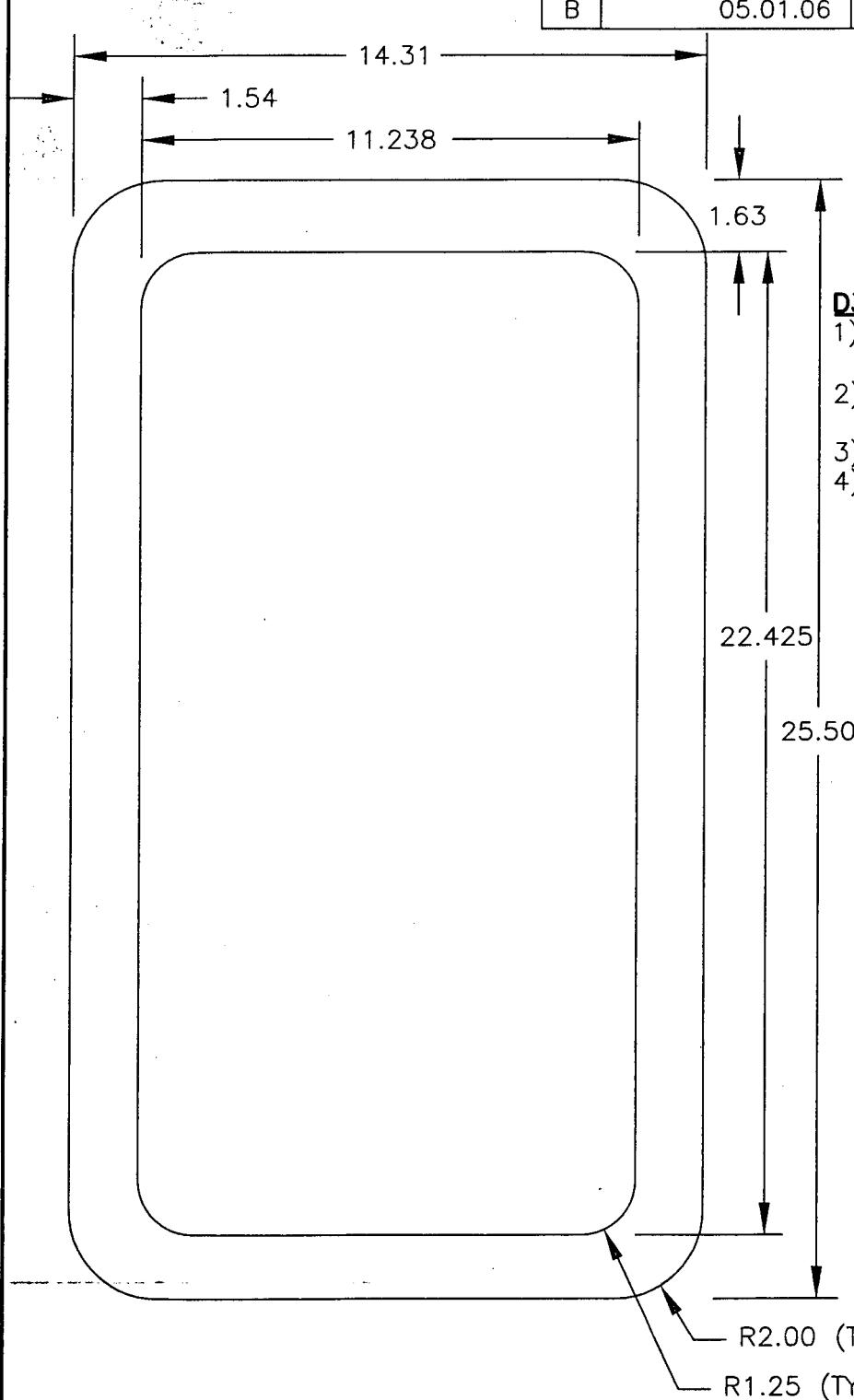
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



| | | |
|----------|----------|---|
| DESIGN | DRAWN BY | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA |
| CHECKED | APPROVED | DRAWING NO. D3240 |
| DATE | | REV. B SHEET 1 OF 1 |
| 05.01.06 | | TITLE FRAME |
| | | SCALE NTS |
| | A | 03.12.18 NEW ISSUE |
| | B | 05.01.06 25.50 WAS 25.19; 14.31 WAS 14.19 |



CERTIFICATE OF COMPLIANCE

CERTIFICAT DE CONFORMITE



Member de / A Member of **Thomas & Betts**

180 LABROSSE AVENUE
POINTE CLAIRE, QC
H9R 1A1

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7

| | | | | | |
|-------------------------|----------|--------------------------------|-------------|----------------|---------------|
| CERTIFICATE NO. | 1 | OUR JOB NO | J0125374 | SHIPPING MEMO | |
| ITEM | QUANTITY | PURCHASE ORDER | PART NUMBER | REV | NAME |
| | 40 PCS | 2007686 | D3240-1 | | FRAME |
| MATERIAL | | SUPPLIED BY | | | MAT. REL. NO. |
| AL 2024-T3 (QQ-A-250/4) | | SAMUEL / KASIER ALUMINUM ATT'D | | | H/N 310277A9 |
| PROCESS | | PROCESSOR | | RELEASE NOTE # | |
| 1 | | | | | |
| 2 | | | | | |
| 3 | | | | | |
| 4 | | | | | |
| 5 | | | | | |
| 6 | | | | | |
| 7 | | | | | |
| 8 | | | | | |
| 9 | | | | | |

WE HEREBY CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED ON RELEASE NOTE SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE DRAWINGS AND PURCHASE ORDER REFERENCED ABOVE.

DATE 31 MARCH 2005

G.F.I. Q.C. REP.

**LES MÉTAUX
SPÉCIALISÉS**
SAMUEL

Programme d'Assurance Qualité Enregistré / Registered Q.A. Program
ISO 9001:2000 AS9100

LETTRE DE CONFORMITÉ –LETTER OF COMPLIANCE

Date: 17 Mars 2005

Company Name: G.F.I. Division of Thomas & Betts limited
Address: 180 avenue Labrosse
City: Pointe Claire, Qué.
Zip Code: H9R 1A1

du client: 0058571

de commande SSMQ: 839445

Customer's order #:

SSMQ's Order #:

La présente est pour certifier que le matériel détaillé ci-dessous est conforme aux exigences de votre commande et des normes du grade tel que décrit:

The following is to certify that the material listed below meets your order requirements and grade standards as described:

| Notre/Our Item # | # de pièces/ # of pieces | Épaisseur/Grandeur Guage/Size | Alliage/Trempe Alloy/Temper | Spécification / Specification | Lot/Heat |
|------------------|--------------------------|-------------------------------|-----------------------------|-------------------------------|----------|
| 1 | 4 | .063" x 48" x 144" | 2024 T3 | AMS-QQ-A-250/4 | 310277A9 |
| | | | | | |
| | | | | | |
| | | | | | |
| | | | | | |
| | | | | | |
| | | | | | |
| | | | | | |

Bien à vous,
Yours truly,

Jean Raymond

Commis à l'administration.
Administration Clerk.



SHIP TO:
 LES METAUX SPECIALISES SAMUEL
 (SHIP TO)
 21525 CLARK GRAHAM
 BAIE D'URFE, PQ, CA H9X3T5

SOLD TO:
 SAMUEL SON & CO LTD
 2225 FRANCIS HUGHES
 LAVAL, PQ, CA H7S1N5

KAISER
ALUMINUM
 Trentwood Works - Spokane, WA 99215
 Phone: (800) 367-2586

CERTIFIED TEST REPORT

Serial Number
 4010594

| CUSTOMER PO NUMBER: | | CUSTOMER PART NUMBER: | | SHIPPING RUN #/LOAD ID: | | GOV'T CONTRACT NUMBER: | |
|---------------------|--------------|-----------------------|-----------|-------------------------|-------|------------------------|--|
| N16146 | | | | 100080/1 | | | |
| KAISER ORDER NO: | LINE ITEM: | SHIP DATE: | ALLOY: | | CLAD: | TEMPER: | |
| 1007108 | 2 | 25-JUN-2004 | 2024 | | BARE | T3 | |
| WEIGHT SHIPPED: | QUANTITY: | B/L NUMBER: | GAUGE: | WIDTH: | | LENGTH: | |
| 7476 LB | 168 PCS EST. | 201906 | 0.0630 IN | 48.00 IN | | 144.000 IN | |

Certified Specifications

AMS 4037/RevN

AMS-QQ-A-250/4/RevA

ASTM B 209/Rev04

Test Code: 1504

Test Results

Lot: 310277A9 Cast 168

Drop 04

Ingot 2

| Tensile: | Temper | Dir / # Tests | Ultimate KSI (MPA) | Yield KSI (MPA) | Elongation % |
|----------|--------|------------------|----------------------------|----------------------------|--------------|
| | T3 | LT / 2 (Min:Max) | 66.9 : 68.2 (461 : 470) | 44.6 : 45.8 (308 : 316) | 16.3 : 17.3 |

| Chemistry: | Si | FE | CU | MN | MG | CR | ZN | TI | V | ZR | OTHER | TOT | 0.03 |
|------------|------|------|------|------|------|------|------|------|------|------|-------|-----|------|
| Actual | 0.09 | 0.23 | 4.49 | 0.56 | 1.39 | 0.01 | 0.09 | 0.01 | 0.01 | 0.00 | | | |

ALLOY LIMITS

| Chemistry: | Si | FE | CU | MN | MG | CR | ZN | TI | V | ZR | OTHER | MAX |
|------------|------|------|------|------|------|------|------|------|------|------|-------|------|
| 2024 MIN | 0.00 | 0.00 | 3.80 | 0.30 | 1.20 | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 | EACH | 0.05 |
| MAX | 0.50 | 0.50 | 4.90 | 0.90 | 1.80 | 0.10 | 0.25 | 0.15 | 0.05 | 0.05 | TOT | 0.15 |

Aluminum Remainder

CERTIFICATION

KAISER ALUMINUM & CHEMICAL CORPORATION (KAISER) HEREBY CERTIFIES THAT METAL SHIPPED UNDER THIS ORDER WAS MANUFACTURED IN THE U.S.A. AND HAS BEEN INSPECTED, TESTED, AND FOUND IN CONFORMANCE WITH THE REQUIREMENTS OF THE APPLICABLE SPECIFICATIONS AS INDICATED HEREIN. ALL METAL WHICH IS SOLUTION HEAT-TREATED COMPLIES WITH MIL-H-6088 (AMS-H-6088). ANY WARRANTY IS LIMITED TO THAT SHOWN ON KAISER'S STANDARD GENERAL TERMS AND CONDITIONS OF SALE. TEST REPORTS ARE ON FILE, SUBJECT TO EXAMINATION. ISO-9001:2000 CERTIFIED

BILL POYNOR, LABORATORIES SUPERVISOR

Bill Poynor